

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004635**Date Inspected:** 29-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

The Quality Assurance (QA) Inspector Gregory Bertlesman arrived on site at the Zhenhua Port Machinery Company facility on Changxing island, China to periodically monitor welding and Quality Control functions. While on site the Quality Assurance Inspector observed and/or discovered the following.

**East Shaft Lift 1**

The Quality Assurance Inspector observed ZPMC continuing to work in the confined spaces. Approximately 15 to 20 ZPMC employees were observed in the shaft. An ABF safety employee was present at the badge tracking board. It appears the diaphragm partial joint penetration welds are being welded to Skins A and B. Below is a digital photograph illustrating the ZPMC employees in the confined space. No work was observed being performed on the exterior of the shaft today.

**East Shaft, Skin A, Lift 2**

ZPMC was observed continuing to perform fit up and tack welding operations to the longitudinal stiffener to skin plate partial and complete joint penetration weld connections utilizing the shielded metal arc welding process.

**South Shaft Lift 1**

ZPMC observed fitting up and tack welding Skin C to the diaphragm plates and in the process of welding temporary fitting aids to Skin C where it joins with skin D. (Skin D was erected yesterday evening 10-28-09. Approximately 5 ZPMC employees were in the confined space. An ABF safety employee was present at the badge tracking board and stated know one with ABF would enter the confined space for two to three days.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---



### Summary of Conversations:

As stated in the contents of the above report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi 137.6471.0411 , who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Bertlesman,Greg	Quality Assurance Inspector
<b>Reviewed By:</b>	Wright,Mark	QA Reviewer

---